

Work Order ID 147777

147777

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Tuesday, June 14, 2016 7:33:26 AM

Item ID: D4020-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: End Mesh, Basket

Start Date: 6/15/2016 Start Qty: 10.00

10*12
10

Cust Item ID:

Required Date: 6/16/2016 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: Rem Date: 16/06/14 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4020	A

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.23

FLOW CNC Waterjet

1-Cut as per Dwg D4020

Dwg Rev: AProg Rev: A

2-Deburr if necessary

(12)

26/06/15

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.02

Quality Control

CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET

(12)

26/06/15

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.03

Quality Control

CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET

(12)

DAS
38
9-89

JUN 15 2016

Work Order ID 147777

147777

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Tuesday, June 14, 2016 7:33:27 AM

Item ID: D4020-11 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: End Mesh, Basket
 Start Date: 6/15/2016 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 6/16/2016 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WNP 04</u>	0.00							
130						12v	25	16-06-15	
Packaging	Memo	0.02							
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140						ML5		JUN 16 2016	
QC	Memo	0.17							
Quality Control									

ML5 JUN 15 2016

Picklist Print

Tuesday, June 14, 2016 7:33:33 AM

Page 1

Work Order ID: 147777

147777

Parent Item: D4020-11

D4020-11

Parent Item Name: End Mesh, Basket

Start Date: 6/15/2016

Required Date: 6/16/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC
per dwg revA 10.03.15 verified by:EC
cut out from dxf, will be made when install on basket DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	765.7000	2.694	28.35789			

M304FX0 75-16F

Expanded Metal Flat SS

06/16/15

Location

Loc Qty

Loc Code

WA004

765.7

M134331

24

M134643

101.7

M134934

640

32

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

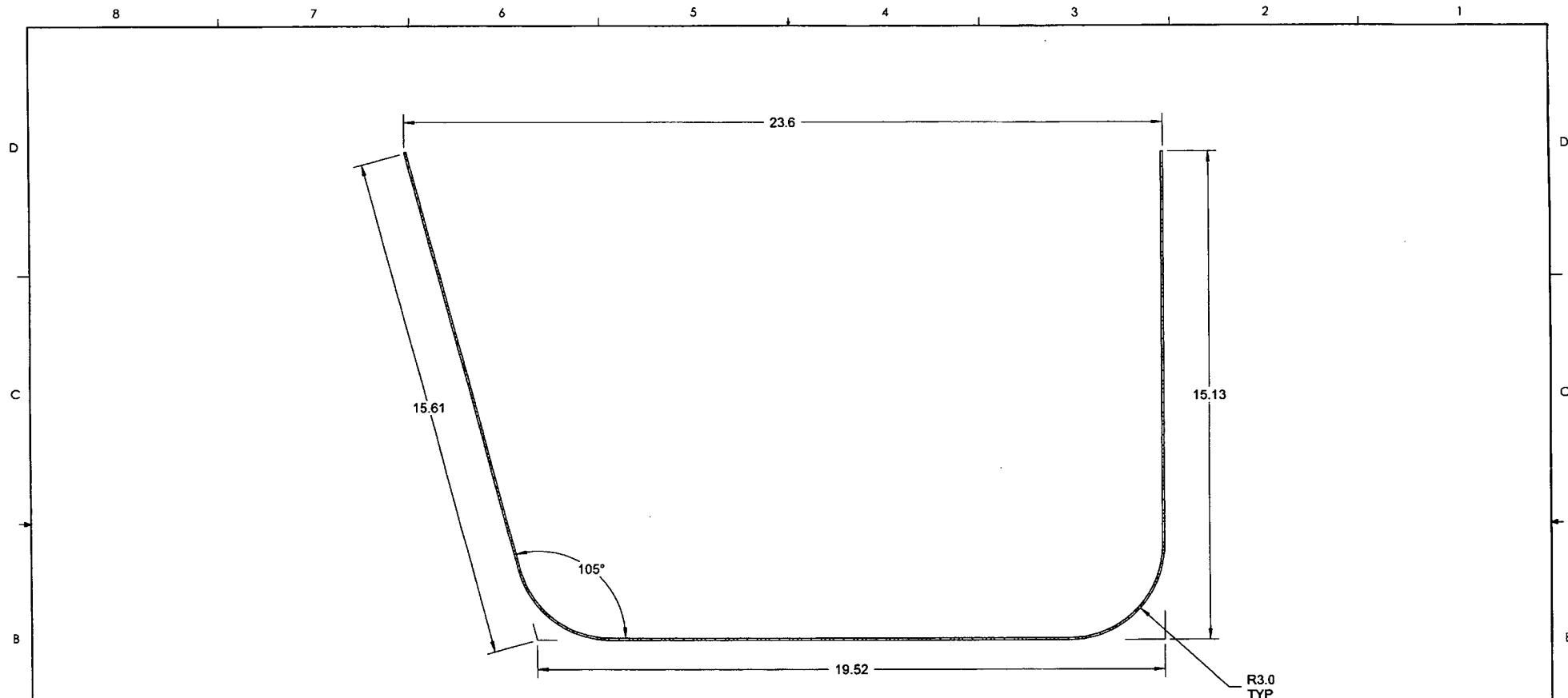
DART AEROSPACE LTD		Work Order:	147777
Description: End Mesh, Basket		Part Number:	D4020-11
Inspection Dwg: D4020 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.34	+/-0.030	24.34	1		Tape	
2.88	+/-0.030	2.88	1			
17.31	+/-0.030	17.31	1			
15.50	+/-0.030	15.50	1			
20.18	+/-0.030	20.18	1			

Measured by:	de	Audited by:	DAS 38	Preliminary Approval:	N/A
Date:	16/06/15	Date:	JUN 15 2016	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.08.03	Dimensions updated	KJ	



9 D4020-1 MESH (350 BASKET LONG, BASE)
(SEE D4020-1F FOR LENGTH)

9 D4020-3 (350 BASKET SHORT, BASE)
(SEE D4020-3F FOR LENGTH)

RELEASED
2010-03-12

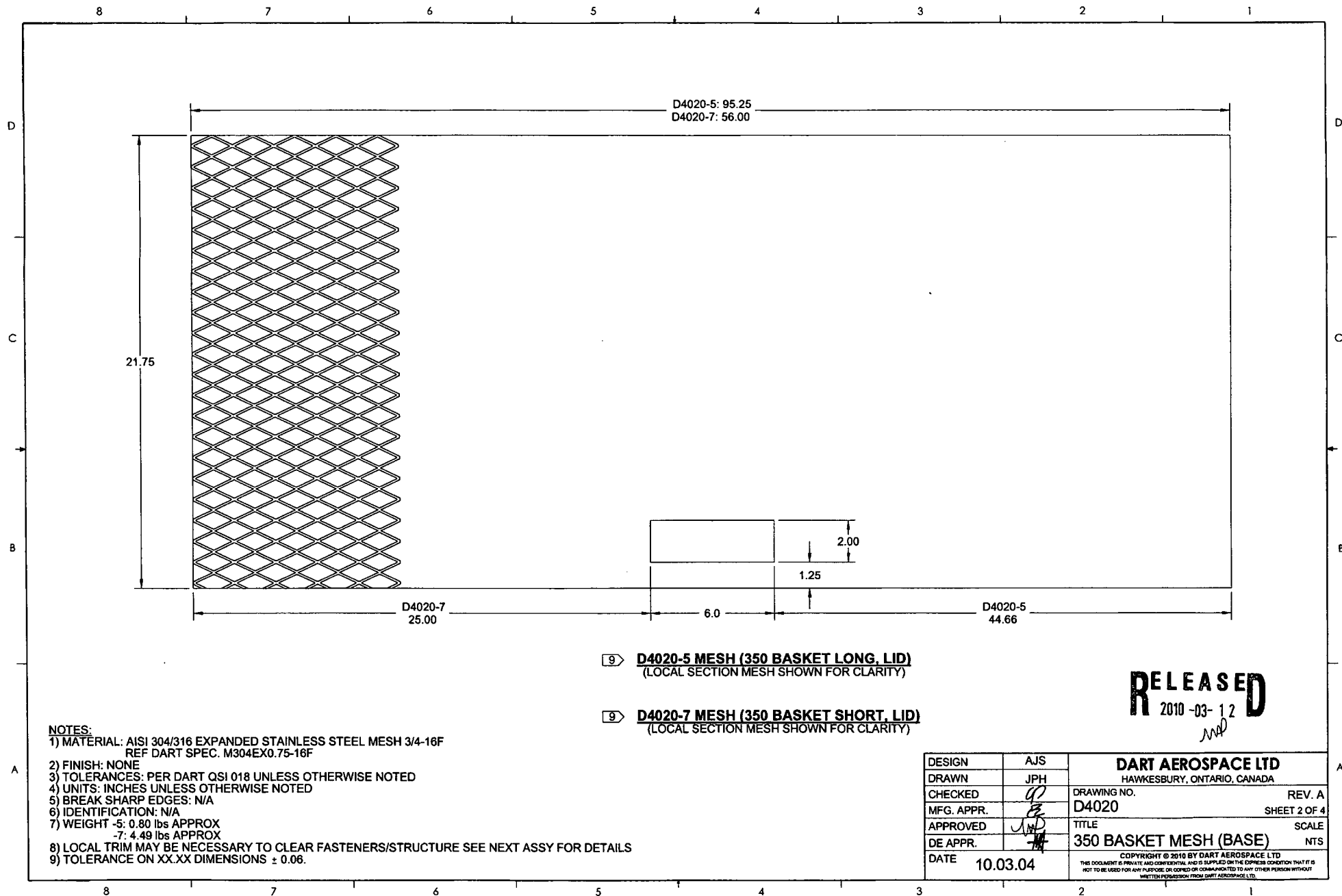
NOTES:

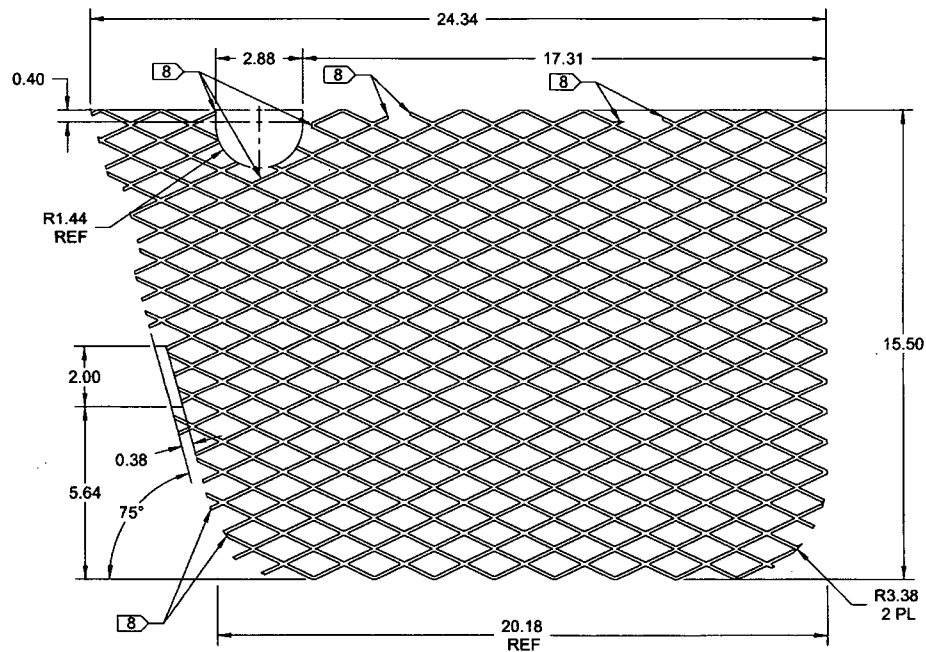
- 1) MATERIAL-1: MAKE FROM D4020-1F
-3: MAKE FROM D4020-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4020-1F & D4020-3F
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	JE	D4020	SHEET 1 OF 4
APPROVED	WDP	TITLE	SCALE
DE APPR.	WDP	350 BASKET MESH (BASE)	NTS
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w/o 147777

dm 10/06/14





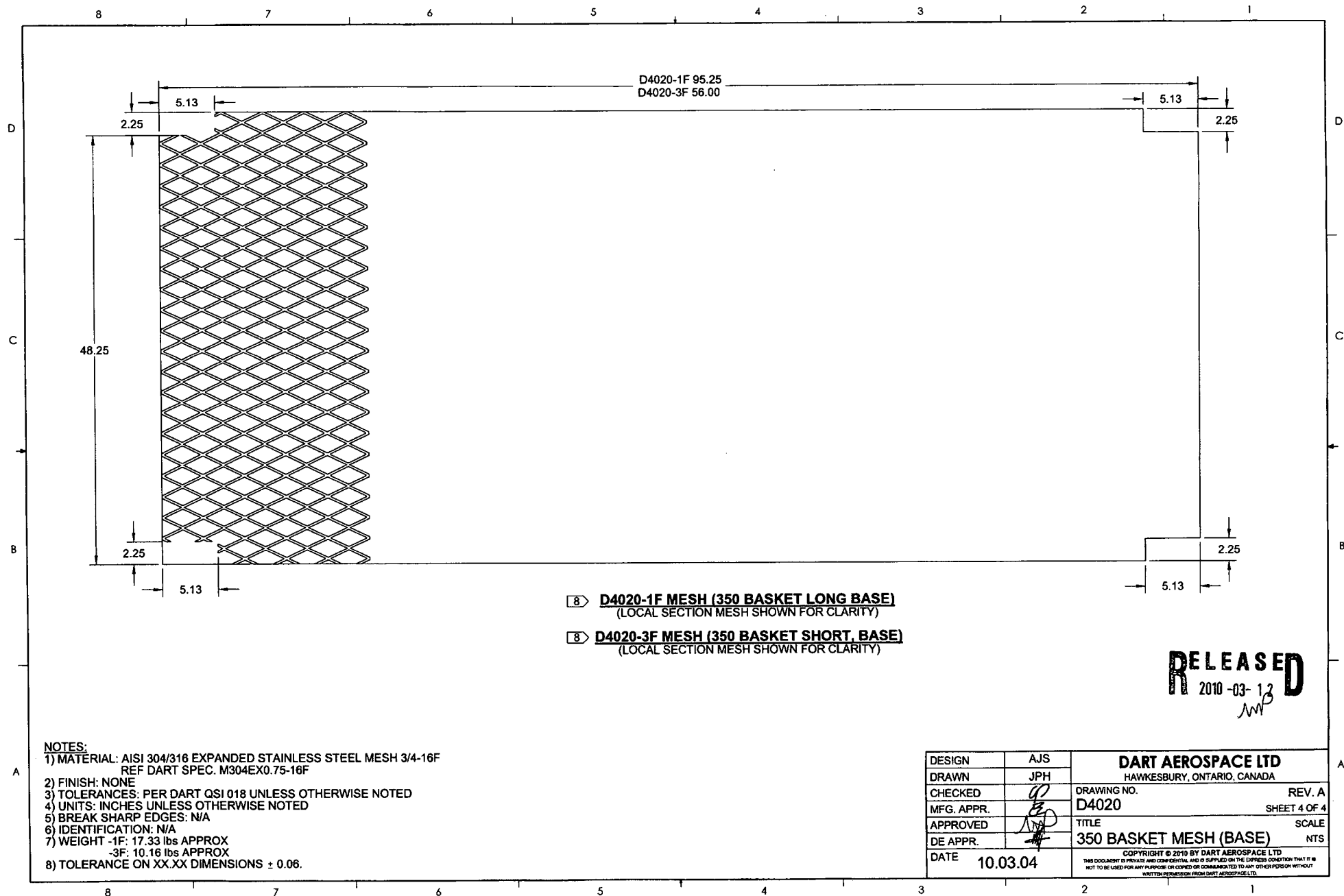
9) **D4020-11 END MESH, BASKET**

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12

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DRAWN	JPH		
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
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